

Date: Thursday, 15/01/2009 8:34:39 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : RIB ASSY (INBOARD)
<b>Job Number</b> : 44771	
<b>Estimate Number</b> : 13661	
<b>P.O. Number</b> :	<b>Part Number</b> : D3827041
<b>This Issue</b> : 15/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3827 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44011	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 22/01/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.01.15</u>	
<b>Comment</b> : Est Rev:A 08-12-01 new issue DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D37591	Bushing
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**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

batch: B44/059 = 7 B44/717 = 5 SP 09.01.21

2.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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**Comment:** Qty.: 8.4000 f(s)/Unit Total : 33.6000 f(s)

304 SQ Tube .75x.75x.065W

batch: M110 335 SAD 09-01-19 (4)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAD 09-01-19 (4)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 02/01/19 (4)

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1- weld bushing in rib as per dwg D3827

A/R ER316 S.S. Rod Batch: M108775 SP 09.01.21 (4X)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

Date: Thursday, 15/01/2009 8:34:40 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (INBOARD)

Job Number: 44771

Part Number: D3827041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- grind weld flush

3- deburr if necessary

SO 09.01.20.

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-22 (4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SO 09.01.22 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket c.

PD 09-01-26 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 (4)

Job Completion



u 09.01.26

W/O:		WORK ORDER CHANGES							
DATE	STEP		PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

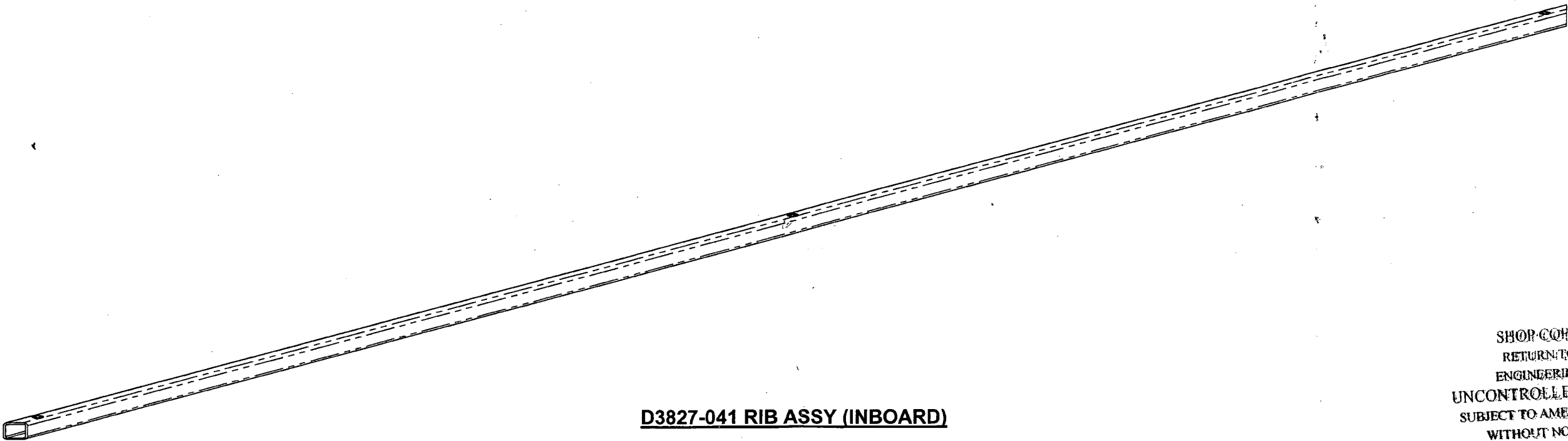
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N /	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44771

RELEASED  
08/11/18

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3827	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (INBOARD)	NTS
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C

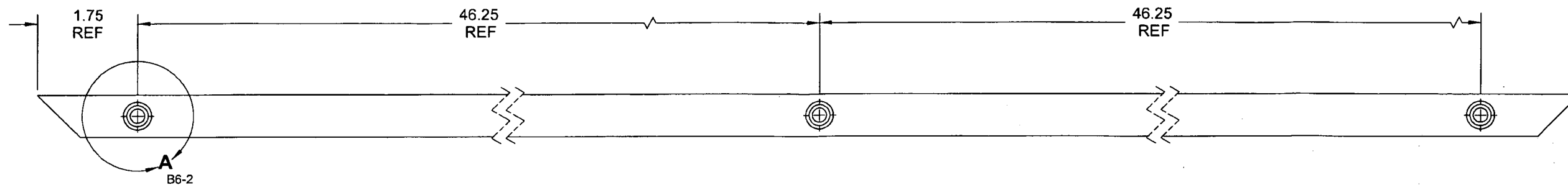
C

B

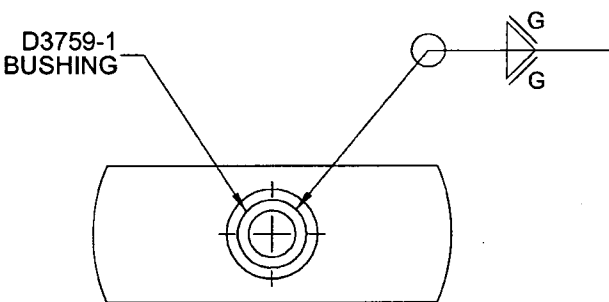
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A

A



**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A**  
SCALE 2X  
3 PL

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WORK ORDER  
NO. 4471

**RELEASED**  
08/11/18 N/A

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>ASS</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>MD</u>	<b>D3827</b>	SHEET 2 OF 3
APPROVED	<u>MD</u>	TITLE	SCALE
DE APPR.	<u>MD</u>	<b>RIB ASSY (INBOARD)</b>	NTS
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8 7 6 5 4 3 2 1





8 7 6 5 4 3 2 1

D

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C

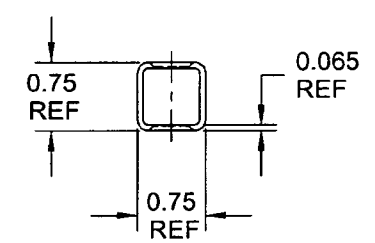
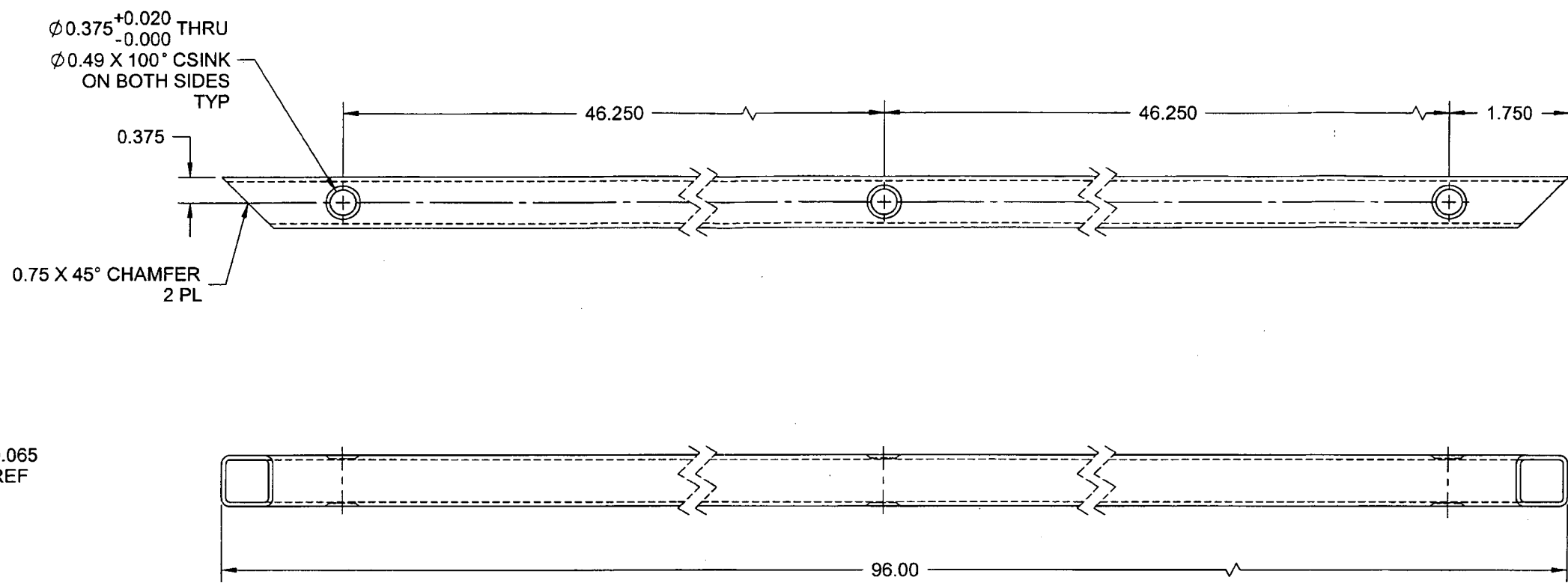
C

B

B

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**D3827-1 RIB**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4477

**RELEASED**  
08/11/12

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.55 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3827	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY (INBOARD)	NTS
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8 7 6 5 4 3 2 1

